

Work Order ID 78485

78485

Page 1

January-10-12 10:15:39 AM

Item ID: D206-628-022

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step RH

Start Date: 1/10/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00 ***2***

Customer:

Reference: REWORK

Approvals: Process Plan: W Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run | Tool ID | Tool # | Plan | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------|---------|--------|------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------|---------|--------|------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| N/A | Rev N/A |

78485

100
100
DC
Document Control

DOCUMENT CONTROL *W*

Memo
Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

W *FORM 15 12-1-25* *(2)*
12-01-25 *(2)*

101
101
HandFinish
Hand Finishing

Memo
PULL FROM STOCK:
2 X D206-628-022BL B71055

STRIP STEPS COMPLETELY

CHG003
M-1/12 12-01-18

102
102
Powdercoat
Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

Start Time: 8:00
Temp: 320°F
Finish Time: 8:30

M-1
12/01/23

78485

| | | | | | |
|--|---------------------|-----|-----------|--|--|
| DART Dart Aerospace Ltd. 1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 | | | | TO APPROVAL # 09-69 TEL: 1-613-632-5200 | |
| PN | D206-628-022BL | CHG | CHG003 | | |
| DESC | Heli-Access-Step RH | STC | SH98-14 | | |
| LOT | B71055 | STC | SA00500SE | | |
| MODEL | Bell 206L/L1/L3/L4 | STC | | | |
| MADE IN CANADA D2729-1 | | | | | |

| | | | | | |
|--|---------------------|-----|-----------|--|--|
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Stop

NS2

Start Date: 1/10/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/13/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

103

QC3- Inspect Part Finish

0.00

103

QC

Memo

0.00

Quality Control

2 BL 12-1-23.

104

0.00

104

HandFinish

Memo

0.00

Hand Finishing

RE-WING WALK A/R

2 BL 12-1-23.

105

QC3- Inspect Part Finish

0.00

105

QC

Memo

0.00

Quality Control

2RH & 11 12/6/12
COUNTED & MEASURED

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Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step RH

Stop ***NS2***

Start Date: 1/10/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | RETURN TO STOCK: (4x) | (4x) | | | | | | | |
| | 8 X D2731-7 BLUE B 71083 | B69177 | | | | | | | |
| | 8 X D3394-043 BLUE B B69180 | 71082 (2x) | | | | | | | |
| | ADD NEW WHITE LUGS TO KITS: | | | | | | | | |
| | 8 X D2731-7 B 75078 | | | | | | | | |
| | 8 X D3394-043 B 74493 | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(12 01 25 2)

(12 01 25 2)

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January-10-12 10:15:39 AM

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Item Name: Heli-Access-Step RH

Stop ***NS2***

Start Date: 1/10/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | REPACKAGE USING NEW B/N | | | | | | | | |
| | Identify and pack for shipping as per PPP D206-628-022 | | | | | | | | |
| | Location: <u>713</u> | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

CH6003

12/12/12 (2)

12/21/12

12-02-01

Picklist Print

January-10-12 10:15:39 AM

Page 1

Work Order ID: 78485

Parent Item: D206-628-022

Parent Item Name: Heli-Access-Step RH

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D as per ECN 766 JLM
IPP Rev:E as per ecn 1118 DD verified by:EC
RUBBER DD verf by:EC IPP Rev:F 10.08.13 CHG QTY OF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| AN4-14A Bolt | | Purchased | No | | | 120 | Each | 124.0000 | 4 | 1117872 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST357 | | 103 | | | | | | | |
| | | | | 118706 | | 3 | | | | | | | |
| | | | | 119798 | | 100 | | | | | | | |
| | | | | ST358 | | 21 | | | | | | | |
| | | | | 119449 | | 21 | | | | | | | |
| AN4-15A Bolt | | Purchased | No | | | 120 | Each | 17.0000 | 8 | 1117423 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST358 | | 17 | | | | | | | |
| | | | | 118706 | | 17 | | | | | | | |
| AN960JD416 Washer | NAS1149D0463J | Purchased | No | | | | Each | 0.0000 | | 24 | 1118179 | | |
| D206-628-022BL Heli-Access-Step RH, Blue | | Manufactured | No | | | | Each | 2.0000 | | 2 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | FG114 | | 2 | | | | | | | |
| | | | | 71055 | | 2 | | | | | | | |
| D2724-042 206L Step Assembly | | Manufactured | No | | | | Each | 0.0000 | | 2 | | | |
| D2731-7 Mounting Lug | | Manufactured | No | | | | Each | 54.0000 | | 8 | 371003 | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST468A | | 4 | | | | | | | |
| | | | | 71860 | | 4 | | | | | | | |
| | | | | ST469 | | 50 | | | | | | | |

Picklist Print

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Work Order ID: 78485

Parent Item: D206-628-022

Start Date: 1/10/12

Required Date: 1/13/12

Parent Item Name: Heli-Access-Step RH

Start Qty: 2.00

Required Qty: 2.00

whf **D2731-7**
Mounting Lug

New

Manufactured No

120 Each 54.0000

4 *B785078*

Location

Loc Qty

Loc Code

ST468A

4

71860

4

ST469

50

whf **D2732-030**
Rubber Cushion

original

Manufactured No

120 Each 4.0000

8 *16*

Location

Loc Qty

Loc Code

ST402

4

64283

4

D3394-043
Lug Assembly

Blue return to sth

Manufactured No

Each 27.0000

16 *B71082* *5A* *B69180* *1x* *B72520*

Location

Loc Qty

Loc Code

ST479

27

74493

27

whf **D3394-043**
Lug Assembly

New

Manufactured No

120 Each 27.0000

4 *8*

Location

Loc Qty

Loc Code

ST479

27

74493

27

whf **MS21042L4**
Nut

original

Purchased No

120 Each 7,915.0000

8 *12* *12/1/28*

Location

Loc Qty

Loc Code

ST300

7915

117441

51

117601

342

118451

133

119017

2389

119075

5000

24

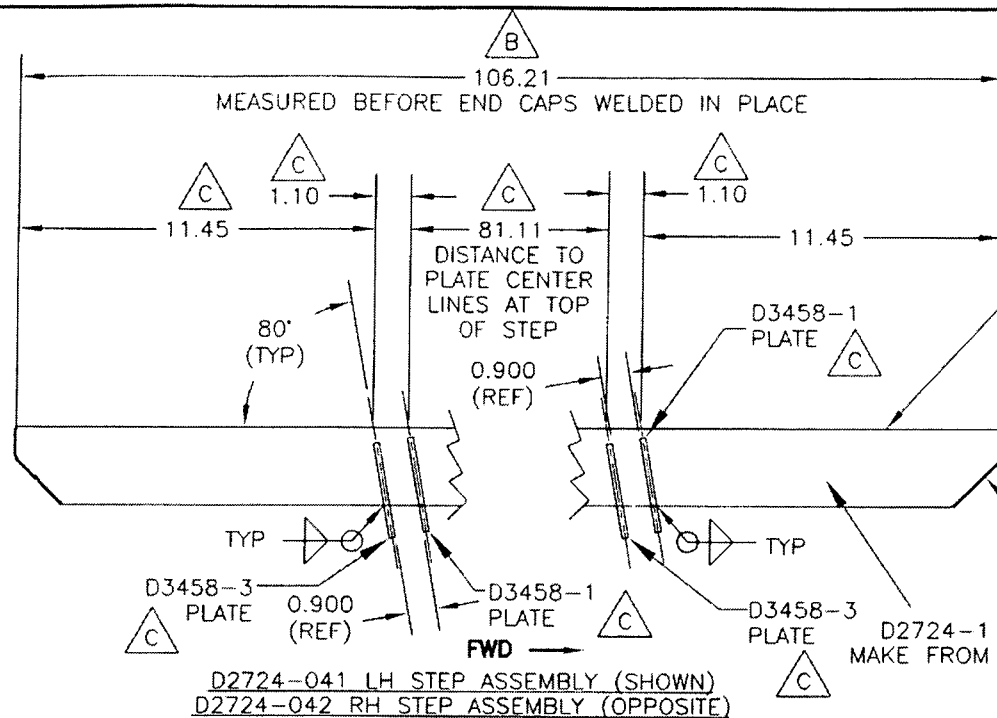
January-10-12 10:15:39 AM

Shop Packet Print

Page 2

RELEASED
OS 11-14
-11-

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS



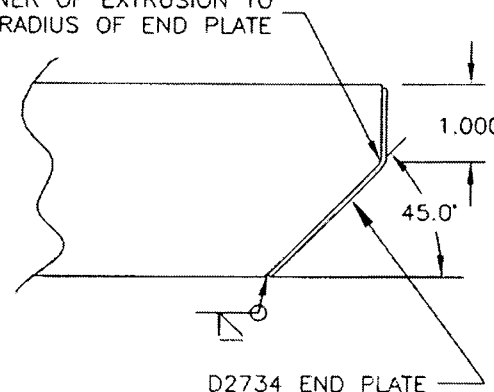
— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

| QTY - 041 | QTY - 042 | PART NUMBER | DESCRIPTION |
|--------------|--------------|-------------|------------------|
| X | | D2724-041 | LH STEP ASSEMBLY |
| | X | D2724-042 | RH STEP ASSEMBLY |
| | | | |
| 1 | 1 | D2622-107 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 2 | 2 | D3458-1 | PLATE |
| 2 | 2 | D3458-3 | PLATE |



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL
NOT TO SCALE

| | | | |
|-------------------------------|---|--|------------------------|
| KE | PH | DARI AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2724 | REV. C SHEET 1 OF 1 |
| DATE 05.09.19 | TITLE 206L/407 STEP ASSEMBLY SCALE NTS | | |
| A | 97.12.04 | NEW ISSUE | |
| B | 98.10.19 | UPDATED WELD DETAIL REVISED TOLERANCES | |
| C | 05.09.19 | RE-DESIGN, ADD D3458-1/-3 | |

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